

Date: Friday, 11/17/2006 9:08:39 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE WELDMENT
Job Number : 29523	
Estimate Number : 12050	
P.O. Number : <i>N/A</i>	Part Number : D3355047
This Issue : 11/17/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3355 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 26924	Material : <i>N/A</i>
Written By : _____	Due Date : 12/10/2006 Qty: 4 Um: Each
Checked & Approved By : <i>061117</i> <i>JA</i>	
Comment : est rev A 06.01.20 new issue (EC)	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33555	medium tubing
-----	--------	---------------



✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 pick:

Qty	Part number	Description
1	D3355-5	medium tubing

Batch

*B26943**Cpl 06.12.18*

(4)

2.0	D33557	small tubing
-----	--------	--------------



✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 pick:

Qty	Part number	Description
1	D3355-7	small tubing

Batch

*B26944**Cpl 06.12.18*

(4)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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✓ **Comment:** LARGE FABRICATION RESOURCE 1
 Weld assembly as per dwg

Cpl 06.12.18

(4)

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------

**Comment:** VISUAL WELDING INSPECTION*12/06/12/19*

(4)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP*12/06/12/19*

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:08:39 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 29523

Part Number: D3355047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M18052



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

FR/FL 07/01/05

(4)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m

07/01/05

(4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: St 366

CPB 07/01/08/ (4)

07/01/08 (4)

9.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07/01/08

Job Completion



u 07-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

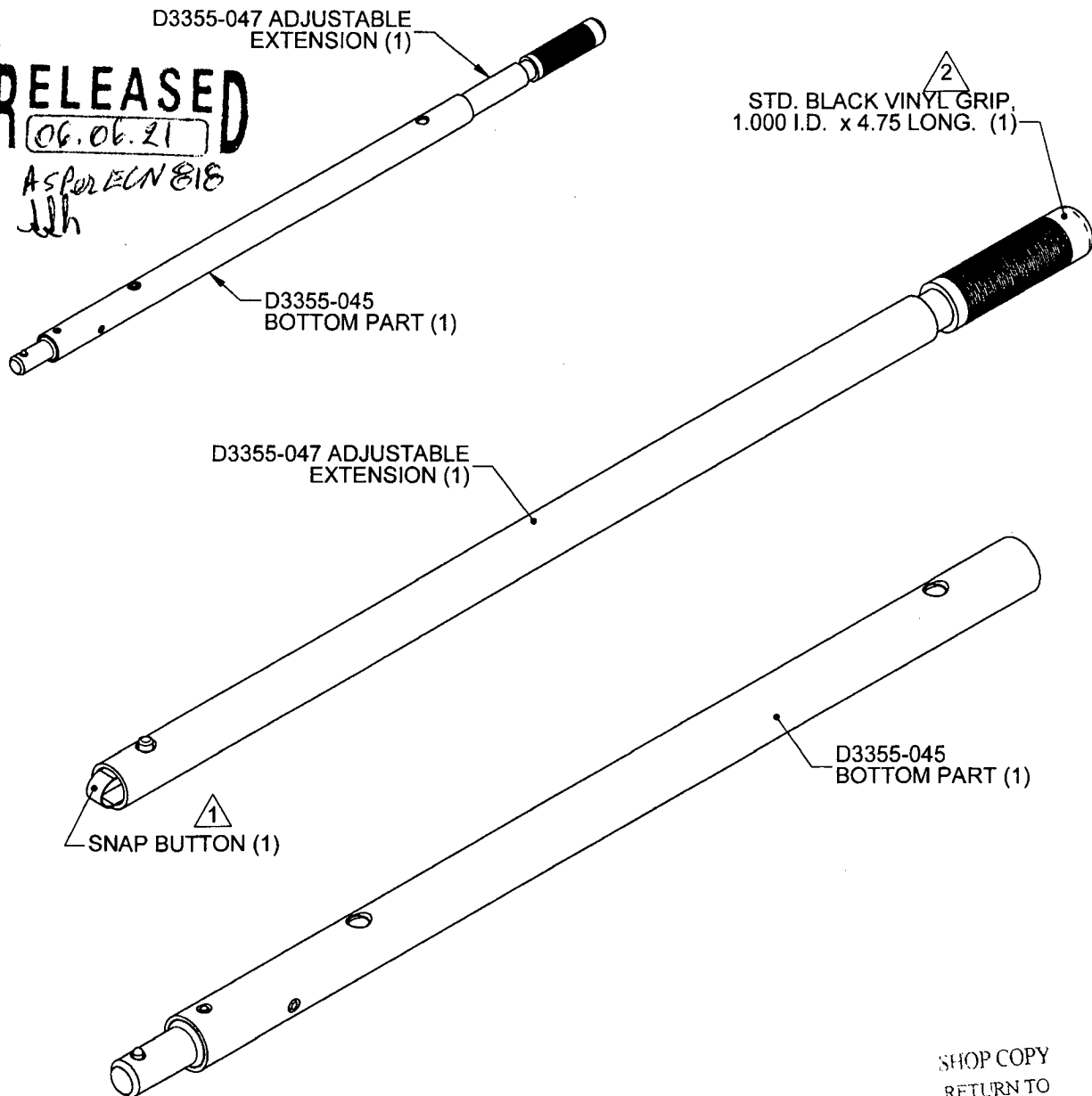
NOTE: Date & initial all entries

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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	

RELEASED
06.06.21

AS PER ECN 818
[Signature]



D3355-041 HANDLE ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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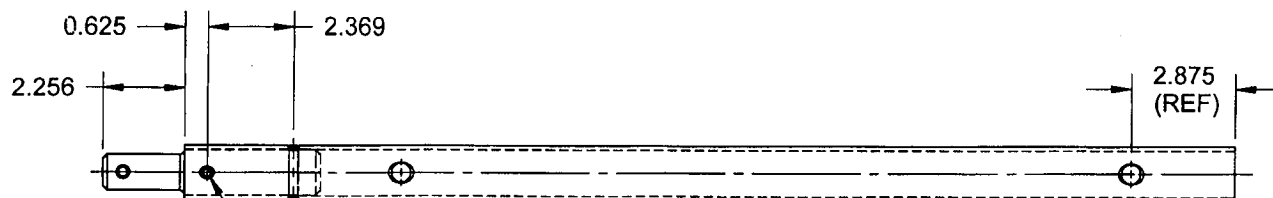
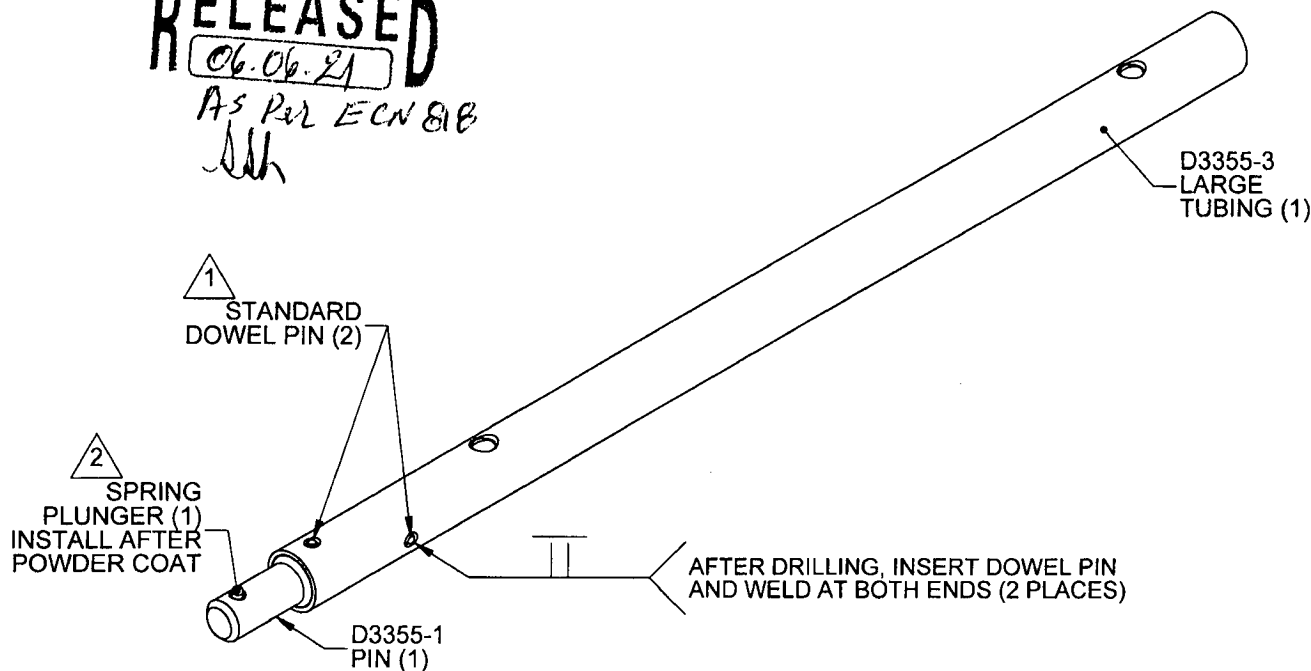
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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06.06.21

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DRILL 90° FROM EACH HOLES
Ø0.250 (DRILL THRU (2 PLACES) AND
CHAMFER 0.06 x 45° (4 PLACES)

D3355-045 BOTTOM PART**NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø0.250 X 1.50 LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N WAH 7150
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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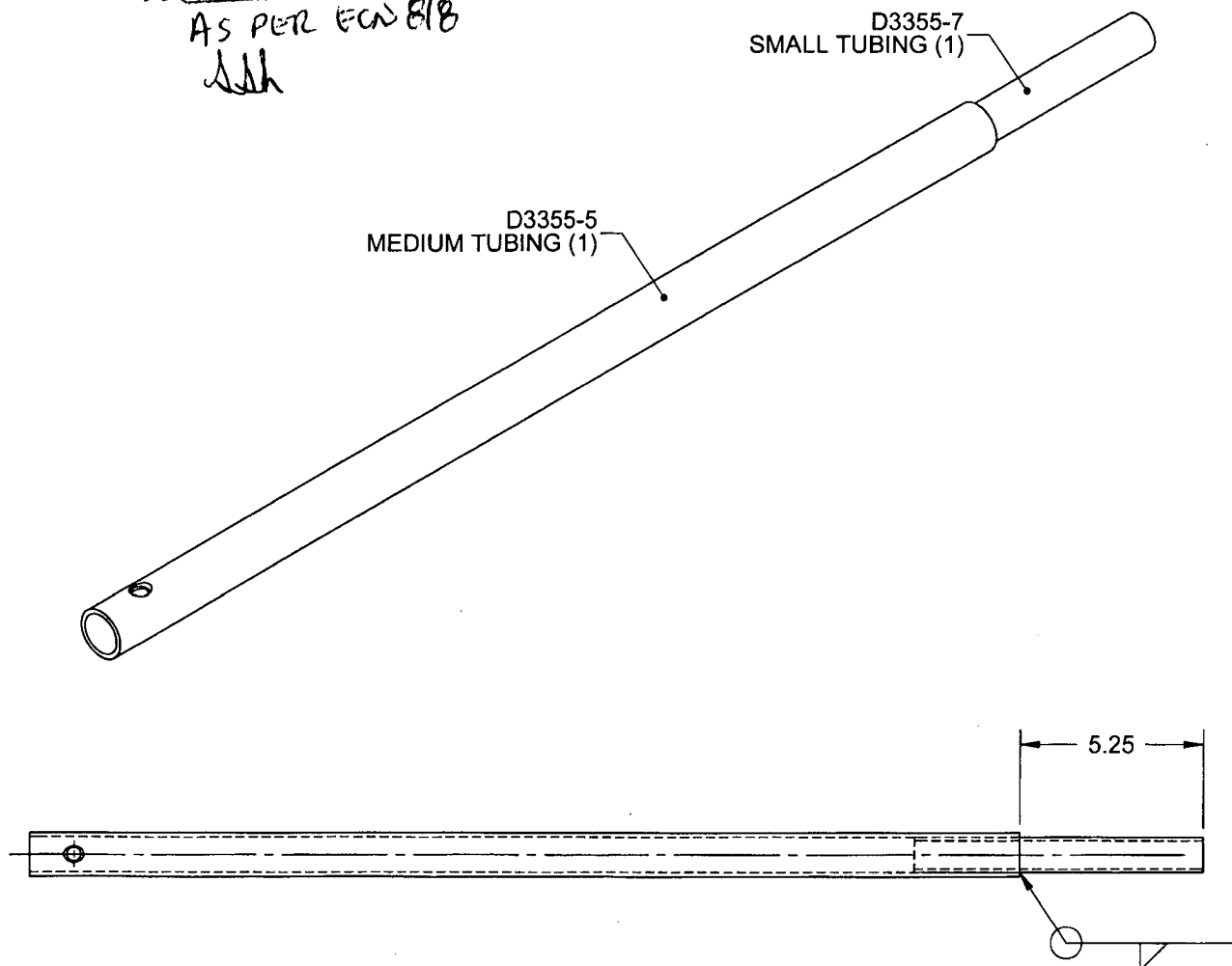


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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AS PER ECN 818

[Signature]



D3355-047 ADJUSTABLE EXTENSION

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

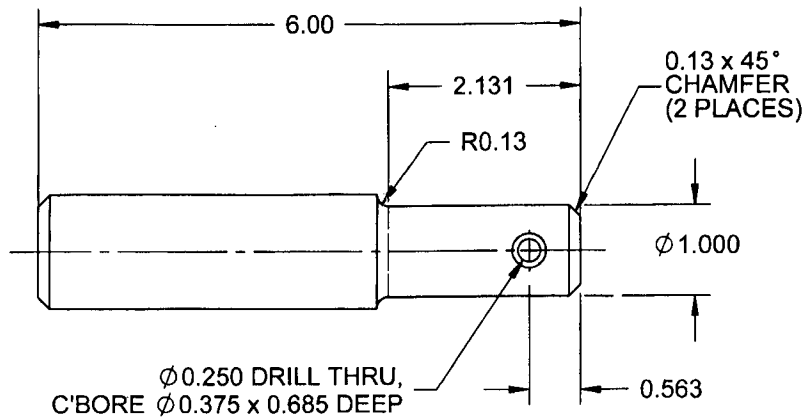
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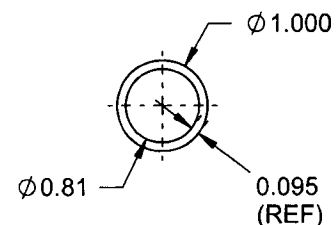
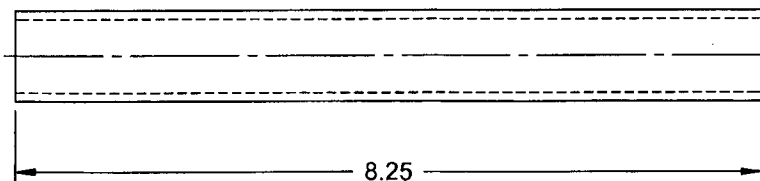
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**RELEASED**
06.06.21
*AS PER ECN 818***D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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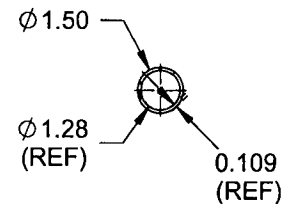
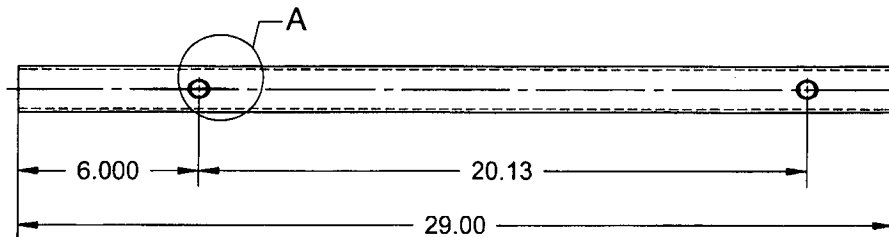
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CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)

DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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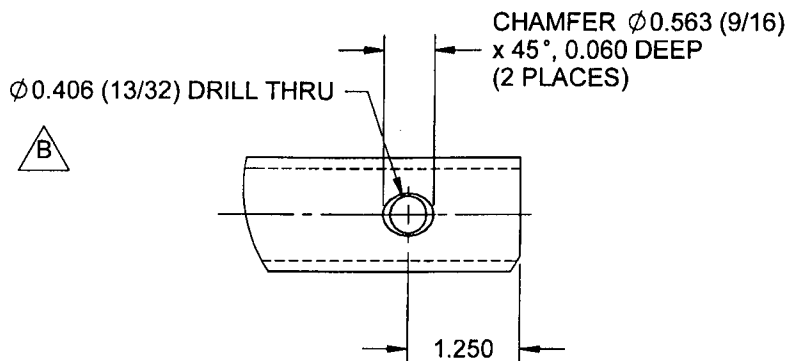
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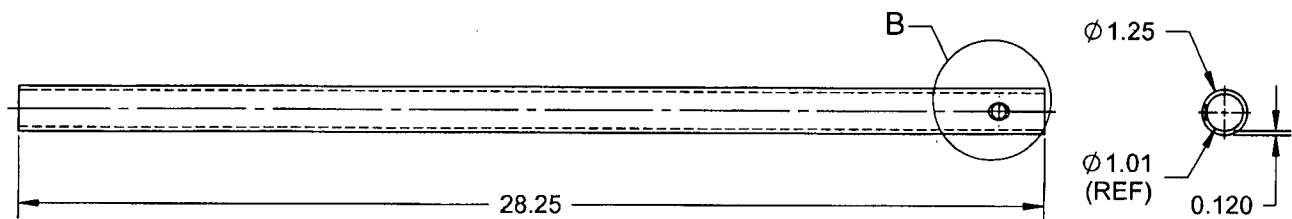
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**DETAIL B
SCALE 1 : 2**



D3355-5 MEDIUM TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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